

*split*  
Work Order ID 69000-1

Wednesday, April 27, 2011 10:42:37 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 4/27/2011 Start Qty: *5* ~~6.00~~



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *11*

Date: *11-04-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble D3912-1/-3/-5 and install rivets as per dwg  
TRIM RIVETS 1.250" LONG

2- Install helical spring plunger and spring pin lanyard assy as per dwg

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Subtotal*

*EP 11/06/08*

*EP 11/06/08*

*EP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 69000

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Page 2

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyeholt Receiver Assembly

Start Date: 4/27/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: S07

0.00



Packaging

Memo

0.00

Packaging

11/6/35 / 50

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/94  
mr  
11-06-09

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 27, 2011 10:42:43 AM

Page 1

Work Order ID: 69000

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly



Start Date: 4/27/2011

Required Date: 4/29/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B  
10.06.10 memo in seq110 \*\*\*IF PLUNGER GOES IN TO DEEP, INSTALL A  
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND  
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO  
FIT\*\*\* DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM  
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R  Washer		Purchased	No				Each	250.0000		6		4/27/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST297				250					
					110139			50					
					116893			200					
D3912-1  Eyebolt		Manufactured	No			100	Each	12.0000	1	6		4/27/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				12					
					68380			12					
D3912-3  Eyebolt Block		Manufactured	No			100	Each	7.0000	2	12		4/27/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				7					
					68378			7					

368973 (47)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Wednesday, April 27, 2011 10:42:43 AM

Page 2

Work Order ID: 69000

Parent Item: D3912-041

Parent Item Name: Eycbolt Receiver Assembly

Start Date: 4/27/2011

Required Date: 4/29/2011

Start Qty: 6.00

Required Qty: 6.00

D3912-5 Manufactured No

100

Each

11.0000

2

12



Eyebolt Plate

Location

Loc Qty

Loc Code

ST091

11

B69001

66160

1

68381

10

Each

12.0000

D3801-1

Manufactured No



Hand Retractable Spring Plunger

Location

Loc Qty

Loc Code

ST084

12

68379

12

Each

228.0000

MS20615-4M20

Purchased No

100



RIVET

Location

Loc Qty

Loc Code

GA

228

117071

228

Each

55.0000

MS21209-F615

Purchased No



Heli-Coil

Location

Loc Qty

Loc Code

ST305

55

108170

34

108244

21

EP 4/06/08

3

EP 4/06/08

6

EP 4/06/08

48

EP 11/06/08

6

Wednesday, April 27, 2011 10:42:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

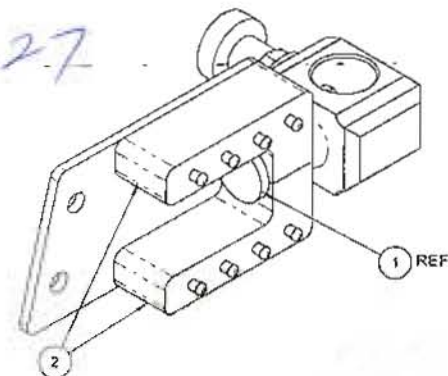
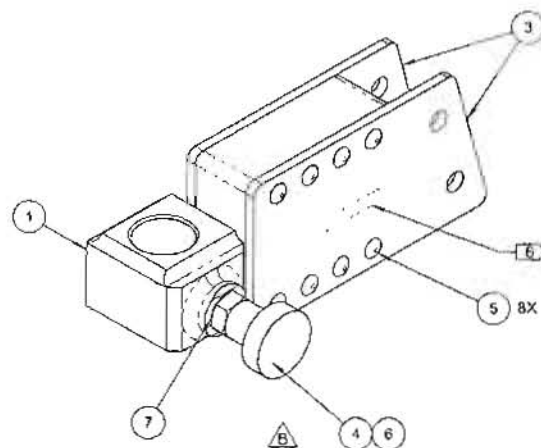
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69000  
P/H-04-27

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3901-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1148P0332P	WASHER



SUPPLEMENTAL ISO VIEW  
(EYEBOLT PLATE REMOVED  
TO SHOW INTERIOR FEATURES)

# D3912-041 EYEBOLT RECEIVER ASSY

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

RELEASED  
2010-07-16

B	D3912-1 WAS D3910-1 SPRING PLUNGER, D4028-041 RMV. MS21209-F615 WAS MS21209-C610 HELICAL, (1) WASHER NAS1148P0332P ADDED, BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV	DESCRIPTION	BY	DATE
DESIGN	1.5		
DRAWN	1.5		
CHECKED	1.5		
MFG. APPR.	1.5		
APPROVED	1.5		
DE APPR.	1.5		
DATE	10.06.28		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3912  
TITLE EYEBOLT RECEIVER ASSY  
REV B  
SHEET 1 OF 3  
SCALE NTS

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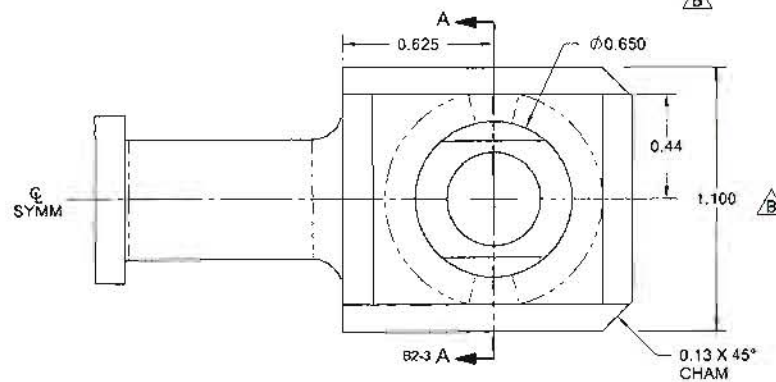
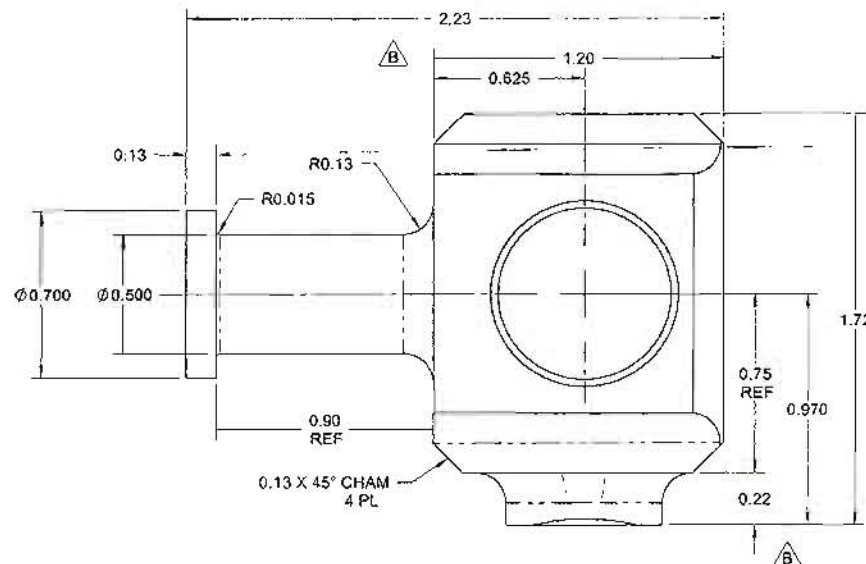
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

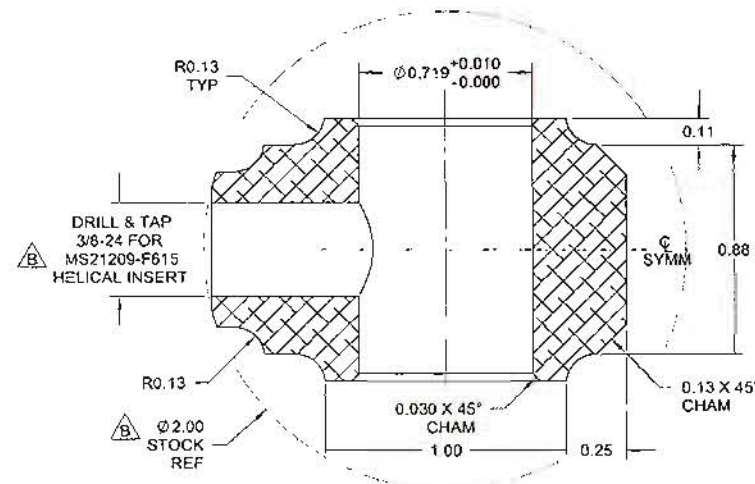
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

**RELEASED**  
2018-07-16

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. B
MFG. APPR		D3912	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD	

u/o 69000

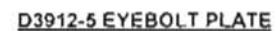
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



1) MATERIAL - 3' 303/304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M303B OR M304B

-5. 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-8059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: ID AT ASSEMBLY  
7) WEIGHT -3: 0.30 lbs  
              -5: 0.24 lbs

RELEASE  
2010-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		MAWESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG APPR		D3912	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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